

Split

Work Order ID 129454 -1

129454

Page 1

Tuesday, February 10, 2015 7:05:45 AM

Item ID: D5152-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

MCS

Date: 1502-10 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5152

PA4

Weld per dwg A/R S.S. rod Batch: 122156 0.00

110

110

Large Fab

Memo

0.00

Large Fab

2

FEB 27 2015

DAS
24
9-89

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

2x

DAS
43
9-89

FEB 27 2015

~~FEB 26 2015~~

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

2x

DAS
43
9-89

FEB 27 2015

~~FEB 26 2015~~

3-40
43
006

FEB 5 9 50P
FEB 5 1 50P

3-40
43
006

FEB 5 9 50P
FEB 5 1 50P

FEB 5 1 50P

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

SprayPaint

Memo

0.00

Spray Painting

Prime as per dwg and QSI005 4.2

Batch: 130128

DAS
41
9-89

15-2-27

150

0.00

150

QC

Memo

0.00

Quality Control

QC14- Inspect Spray Paint

2

15/02/27

DAS
51
9-89

160

0.00

160

Packaging

Memo

0.00

Packaging

Identify as per dwg & Stock Location

654

2

DAS
41
9-89

15-2-27

2241
P
3

2241
P
3

2241
P
3

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Page 3

Item ID: D5152-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

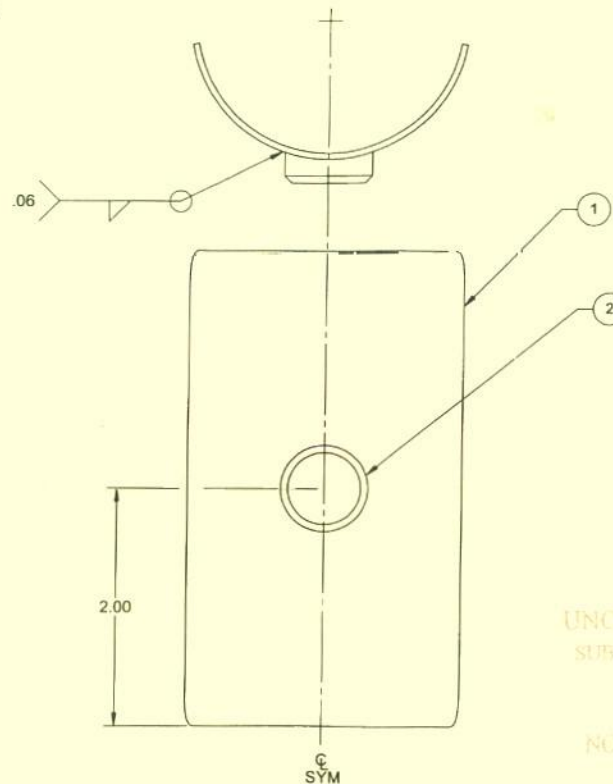
0.00

Quality Control

MLD 15-03-03

H5.3-3

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5152-041	FWD POST MOUNT ASSY
1	1	D5152-1	FWD POST MOUNT
2	1	D5152-5	FWD STEP POST



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 129454 MLJ

15-02-10

RELEASED

2015 FEB 09

ECN 15-516 9

D5152-041 FWD POST MOUNT ASSEMBLY

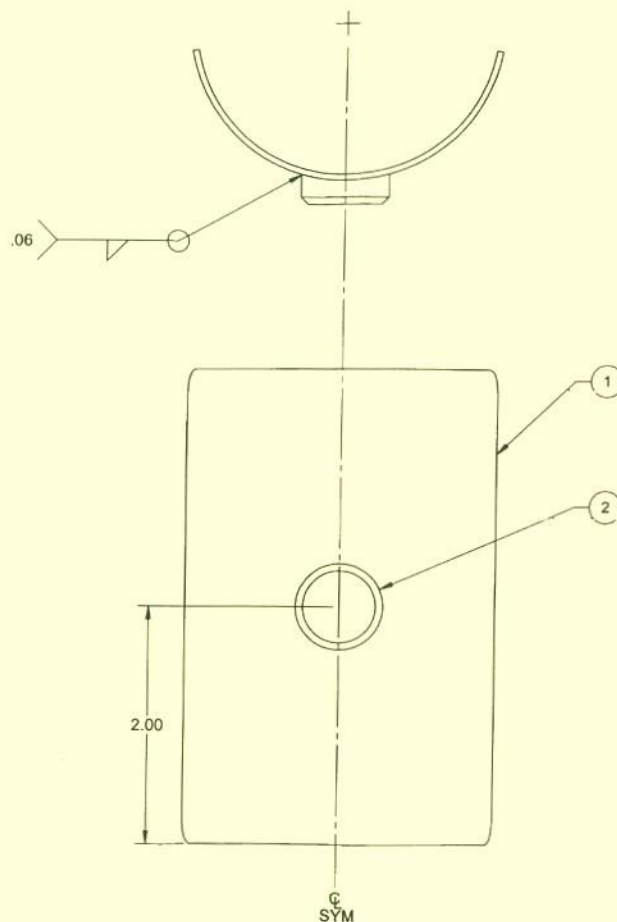
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-041= 0.21 lbs

APPROVED

B	COMPLETE REDESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.09
A	NEW ISSUE	DB	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5152-043	AFT POST MOUNT ASSY
1	1	D5152-3	AFT POST MOUNT
2	1	D5152-7	AFT STEP POST



D5152-043 AFT POST MOUNT ASSEMBLY

NOTES:

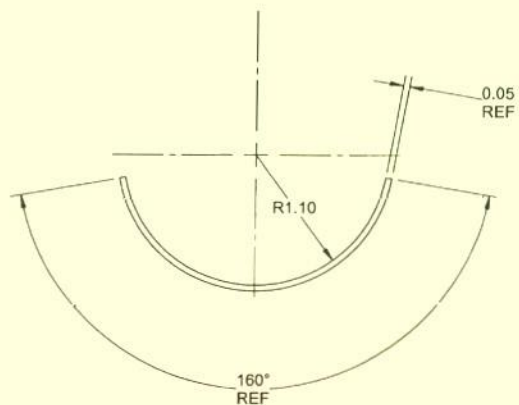
- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-043= 0.23 lbs

RELEASED

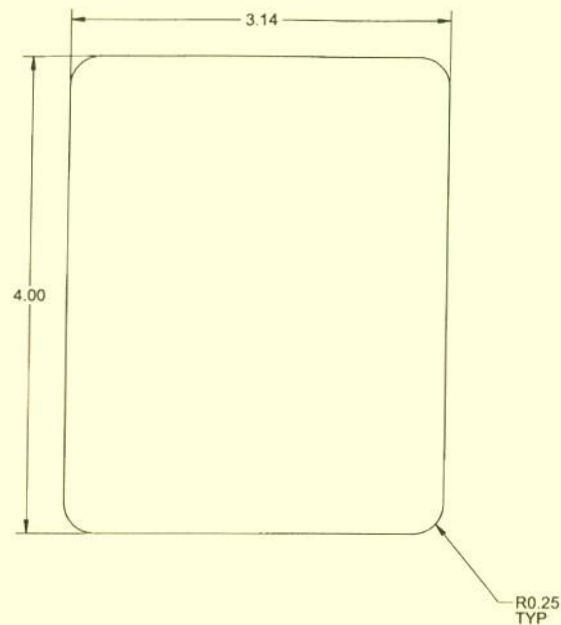
2015 FEB 09

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D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

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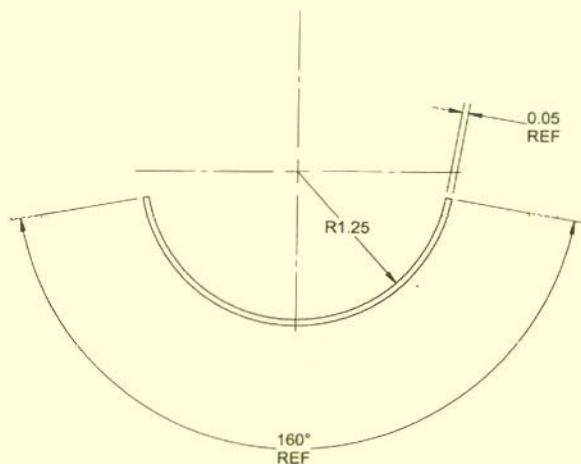
2015 FEB 09

NOTES:

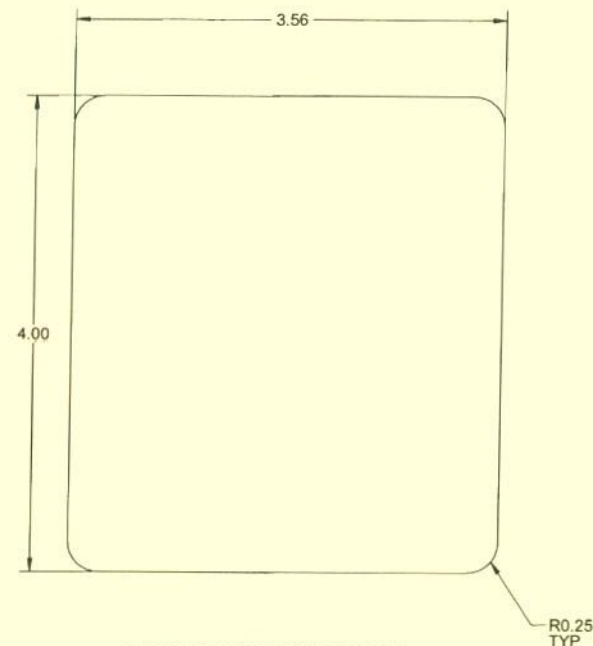
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 3 OF 5
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D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

R1.150

R1.300

0.20

0.20

0.06 X 45° CMF

0.06 X 45° CMF

Ø0.725

Ø0.725

D5152-5 FWD STEP POST

D5152-7 AFT STEP POST

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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8 7 6 5 4 3 2 1

